

Date: Thursday, 10/25/2007 10:03:50 AM
 User: Kim Johnston

Process Sheet

44

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW INSTALLATION
 Job Number : 35348
 Estimate Number : 10044
 P.O. Number : *N/A* Part Number : D044662011
 This Issue : 10/25/2007 S.O. No. : *N/A* Drawing Number : D3075 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 30791 Material : *N/A*
 Due Date : 11/2/2007 Qty: 10 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 10.25
 Comment : Est Rev:C 04.02.19 Added tolerance and ref to DSK086-12 to
 Step 3 KJ/JLM
 Est Rev:D As per ECN 932 & 862 06-07-28 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 35348A R44 BEARPAW



Comment: Sub-Component R44 BEARPAW

D3075-1

B 35154A

2.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD044-662-011 CHG003

A 12/04

3.0 D2182B Neoprene Cushion-.750 bl



Comment: Qty.: 0.9300 f(s)/Unit Total: 9.3000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B028 Rubber Cushion

1 Paperwork package

B30872 (8x)

B30397 (5x)

B34777 x32

4.0 D2529 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer

B32025

AS 07/11/12

5.0 D35561 Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Clamp

Batch:

B31632 (8x)

B35361 x10

AS 07/12/04

K12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:03:50 AM

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 35348

Part Number: D044662011

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D36011

RADIUS BLOCK



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

RADIUS BLOCK

Batch:

B31634

(x40)

B31539

(x40)

AS 07/11/12

(x12)

7.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN4-14A Bolt

M102473

~~M102473~~

AS 07/11/12

(x12)

8.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN4-15A Bolt

M104746

AS 07/11/12

(x12)

9.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416 Washer

M105426

AS 07/11/12

(x12)

10.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4)

M105054

AS 07/11/12

(x12)

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 07/12/04 (x12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:03:50 AM
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Drawing Name: BEARPAW INSTALLATION

Job Number: 35348

Part Number: D044662011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-662-011

Location: _____

AS 07/12/04 (X12)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(12) 07/12/06

Job Completion



U 07-12-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

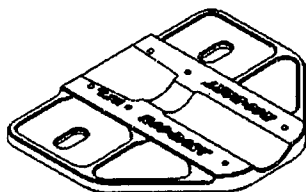
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

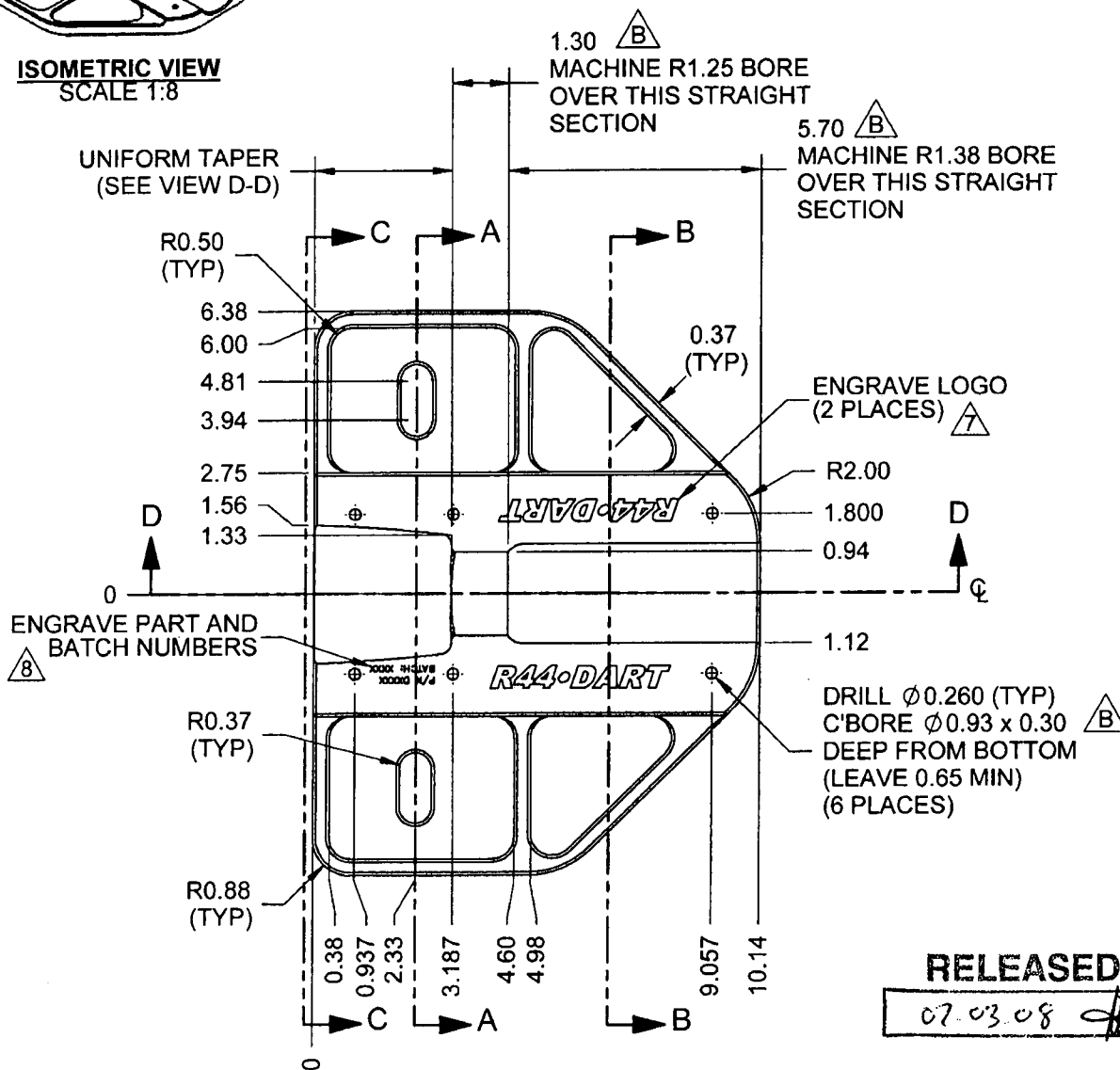
NOTE: Date & initial all entries



DESIGN #1	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #3	APPROVED #1	DRAWING NO. D3075	REV. B SHEET 1 OF 2
DATE 07.02.27		TITLE R44 BEARPAW	SCALE 1:4
REV	DATE	DESCRIPTION	
A	02.01.04	NEW ISSUE	
B	07.02.27	1.30 WAS 1.60; 5.70 WAS 5.84; $\phi 0.93$ WAS $\phi 0.75$; ADD QTY(2) HOLES AT (0.937, ± 1.800)	



ISOMETRIC VIEW
SCALE 1:8



D3075-1 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO $\phi 0.950$)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

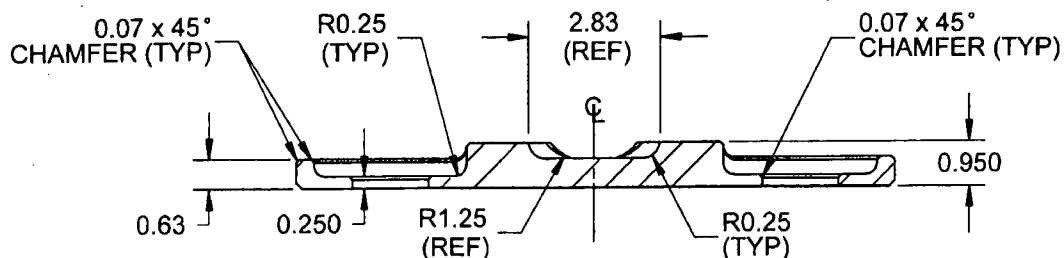
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WITHOUT NOTICE
WORK ORDER
NO. 35348

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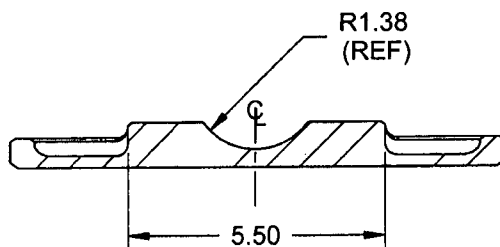
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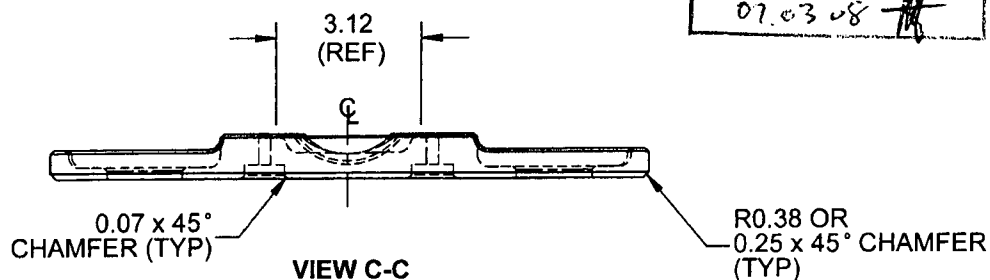
DESIGN #1	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #3	APPROVED #	DRAWING NO. D3075	REV. B SHEET 2 OF 2
DATE 07.02.27		TITLE R44 BEARPAW	SCALE 1:4



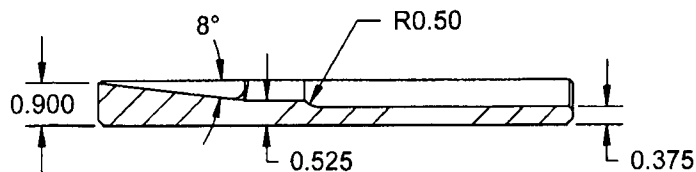
SECTION A-A



SECTION B-B



VIEW C-C



SECTION D-D

RELEASED

07.03.08

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